

54408 Drev

Work Order ID 52793



Page 1

October 14, 2009 10:45:05 AM

Item ID: D3391-023

Accept



Setup Start



Revision ID: H

Stop



Item Name: Mid Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *BP*Date: *09-10-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

RD
*9-10-16**AWN* *9-10-23*

Work Order ID 52793

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence-ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
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Rev. CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Open .375" holes to .438" ***do not open fwd saddle holes***

-AWM 9-10-22

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021, using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drilol remaining 6 wearplte holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

1

H 9/10/26

Work Order ID 52793

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Item ID: D3391-023

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Item Name: Mid Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00

Required Date: 02/11/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	278 02/10/27						
120 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	11 9/10/27		
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00					BE 09/10/27		




Work Order ID 52793

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Item ID:	D3391-023	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Mid Tube Assembly					
Start Date:	14/10/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	02/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

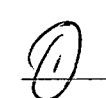
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	Skidtubes	0.00				1		11 9/10/27	
Skidtubes	Memo	0.00							
Skidtubes	1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours)								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
160 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush								

BF M112391
Exe. 10/2/30


27 Seal tubes





BE 09/10/28

A/R M11/999


9-10-28

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Item ID:	D3391-023	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Mid Tube Assembly					
Start Date:	14/10/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	02/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
190 Powdercoat Powder Coating	* PRESSURE - WASH White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112142 Memo START TIME: 9:15 AM OVEN TEMPERATURE: 320°F FINISH TIME: 9:45 AM	0.00 0.00							

=> 808/10/28

=> 808/10/28

=> 41 09/10/29

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

Bk 02-12-01

0,

Memo

0.00

210



Skidtubes

Skidtubes

Skidtubes

0.00

=> H1 09/12/01

(X)

d

Memo

0.00

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes



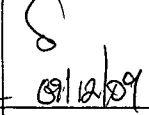
3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.12.01	Z10	HOLES WOULDN'T ALIGN AT FWD SADDLE, ACCEPTABLE TO FILE INNER HOLE TO ALLOW FIT		09/12/01	(X1)	 09.12.01 05/04/02	 09/12/01

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

w/053516 0.00

09/12/01

(41)

Packaging

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/08

MF

09-12-08

Picklist Print

October 14, 2009 10:45:15 AM

Page 1

3

Work Order ID: 52793



Parent Item: D3391-023RevH



Parent Item Name: Mid Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-100RevU/R		Manufactured	No			100	Each	0.0000	1.0000			
							B 37265			1	14/10/2009	
Skidtube Extrusion												
D3391-021RevH		Manufactured	No			100	Each	0.0000	1.0000			
							B 52359			1	14/10/2009	
Fwd Tube Assembly												
D3389-1RevD		Manufactured	No			140	Each	9.0000	1.0000			
Web												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

47303

1

48244

1

48245

1

48246

1

48247

1

50226

4

14/10/2009

Picklist Print

October 14, 2009 10:45:15 AM

Work Order ID: 52793



Parent Item: D3391-023RevH



Parent Item Name: Mid Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3681-1RevA		Manufactured	No			160	Each	89.0000	5.0000			
Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

20

51920

20

Main Warehouse

ST

69

47123

13

48178

56

6
4
8E 09/10/28
8E 09/10/28

D3591-1RevB

Manufactured

No

210

Each

73.0000

2.0000



Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

73

46105

29

47121

44

X2 09/12/01

Picklist Print

Page 3

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Work Order ID: 52793



Parent Item: D3391-023RevH



Parent Item Name: Mid Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS4-1032-130

Purchased

No

230

Each

5,373.000

22.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

110511

1111529

5373

5373

(X.22)

24 09/12/01

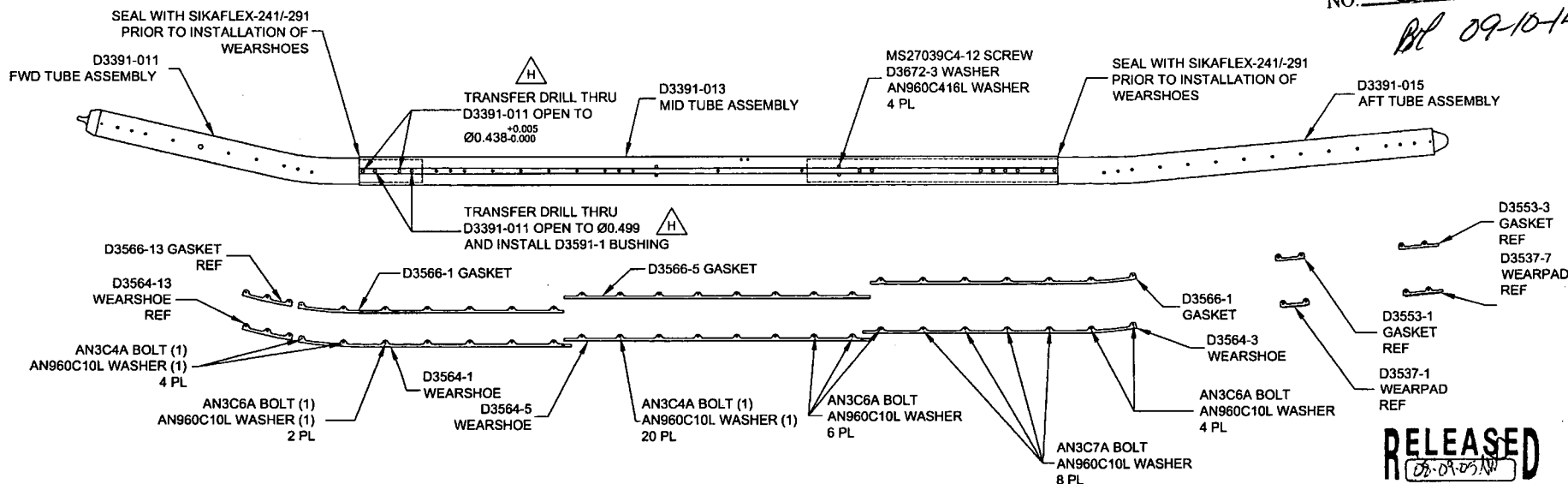
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Shop Packet Print

Page 3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52793
09-10-14



D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

D

C

B

A

SEAL WITH SIKAFLEX-241/-291 PRIOR TO INSTALLATION OF WEARSHOES

D3391-021 FWD TUBE ASSEMBLY

TRANSFER DRILL THRU D3391-021 OPEN TO $\begin{smallmatrix} +0.005 \\ \text{Ø}0.438-0.000 \end{smallmatrix}$

D3391-023 MID TUBE ASSEMBLY

SEAL WITH SIKAFLEX-241/-291 PRIOR TO INSTALLATION OF WEARSHOES

D3391-025 AFT TUBE ASSEMBLY

TRANSFER DRILL THRU D3391-021 OPEN TO Ø0.499 AND INSTALL D3591-1 BUSHING

D3566-13 GASKET REF

D3564-13 WEARSHOE REF

AN3C4A BOLT AN960C10L WASHER 4 PL

AN3C6A BOLT AN960C10L WASHER 2 PL

D3566-1 WEARSHOE

D3564-5 WEARSHOE

AN3C4A BOLT AN960C10L WASHER 20 PL

AN3C6A BOLT AN960C10L WASHER 6 PL

AN3C7A BOLT AN960C10L WASHER 8 PL

D3566-1 GASKET

D3564-3 WEARSHOE

AN3C6A BOLT AN960C10L WASHER 4 PL

D3553-3 GASKET REF

D3537-7 WEARPAD REF

D3553-1 GASKET REF

D3537-1 WEARPAD REF

D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-043		
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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RELEASED

08-09-2018

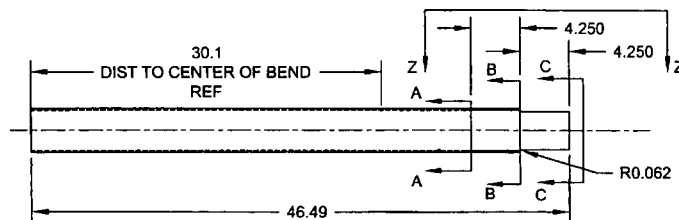
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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
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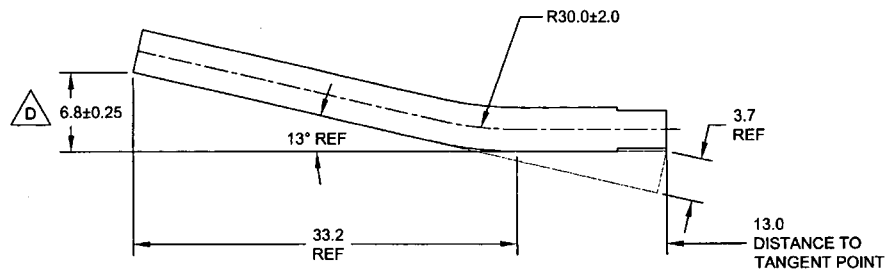
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08-09-25 AM

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APPROVED		TITLE	SCAL
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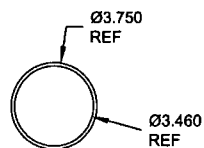
W/O 52793



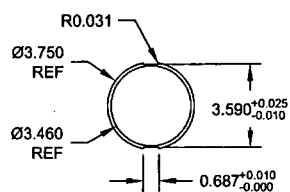
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



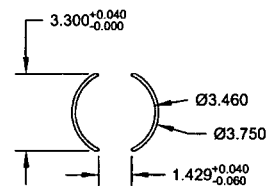
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



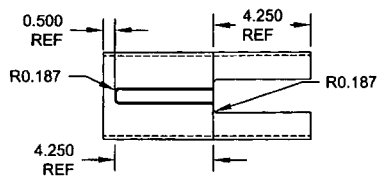
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

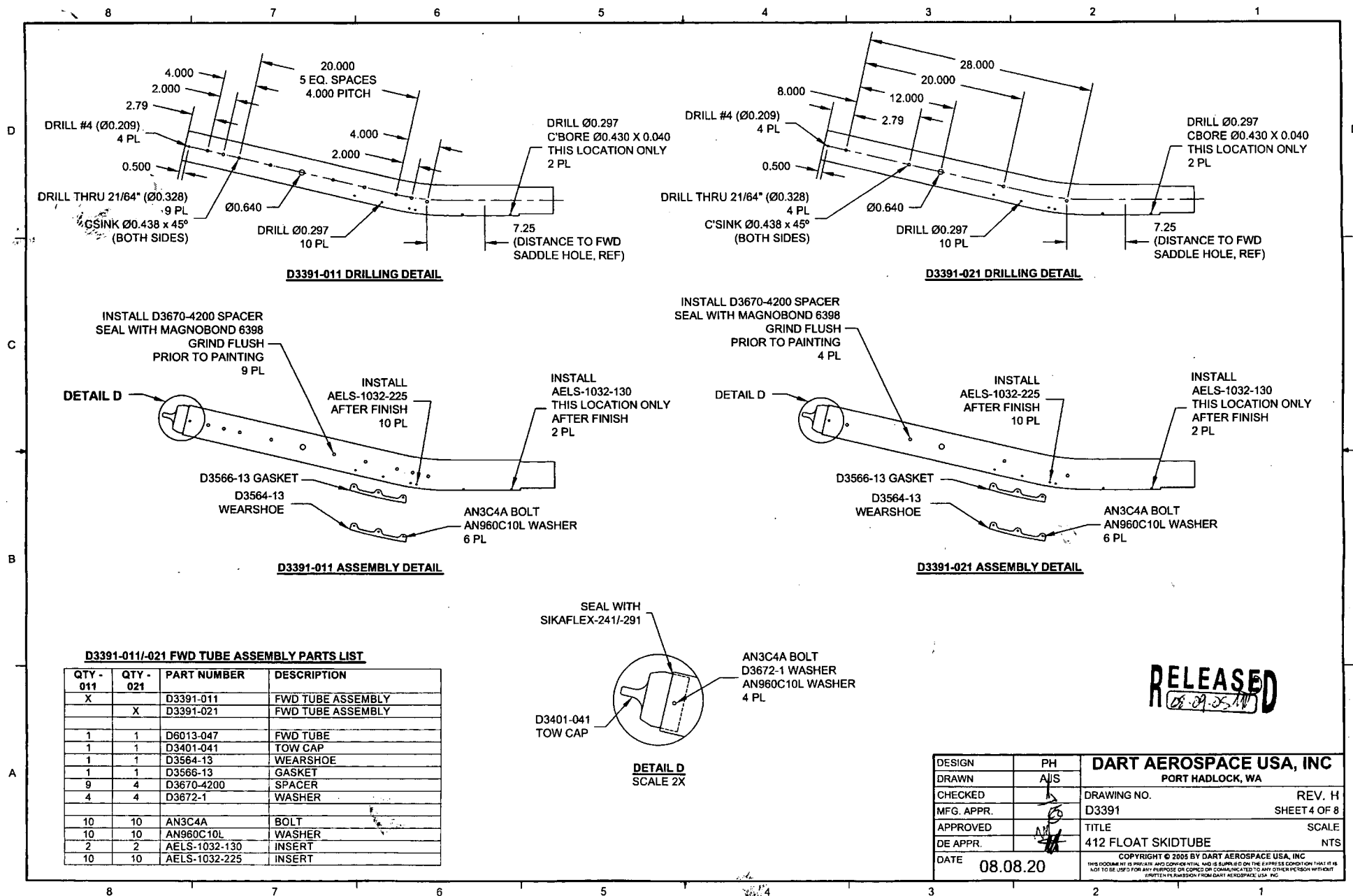


VIEW Z-Z
SCALE 2X

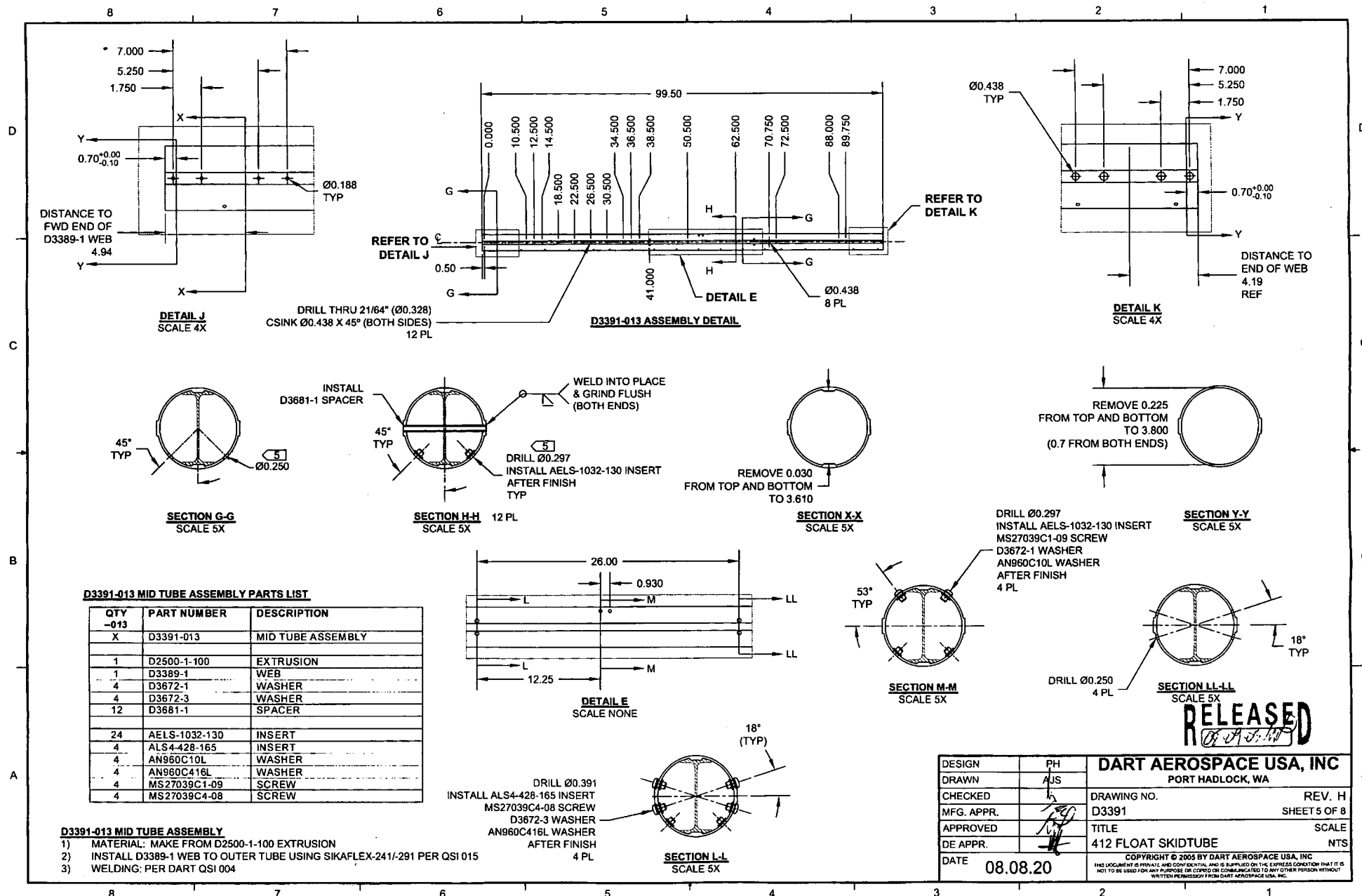
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2017-05-11

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APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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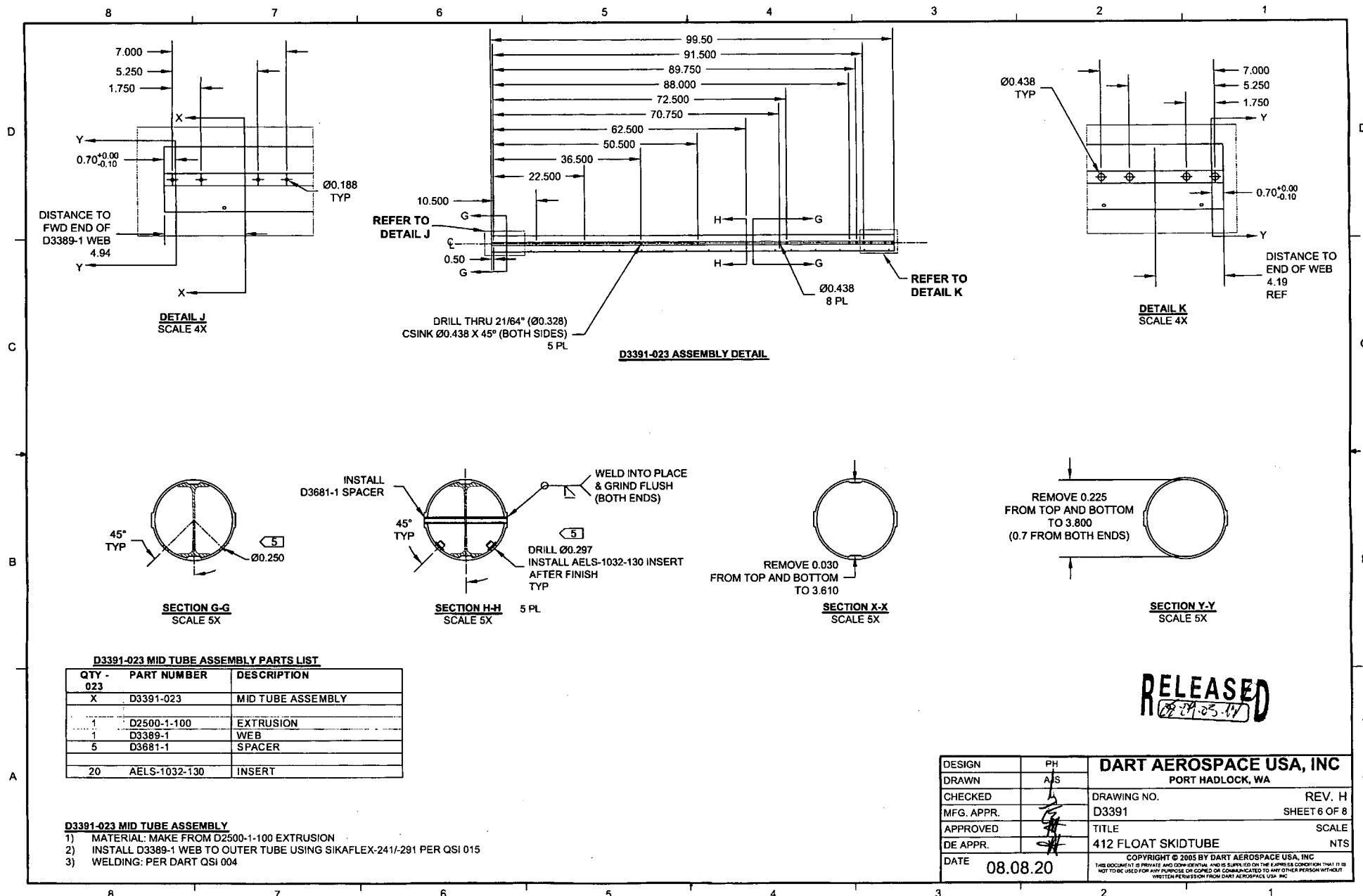
w/b 52793



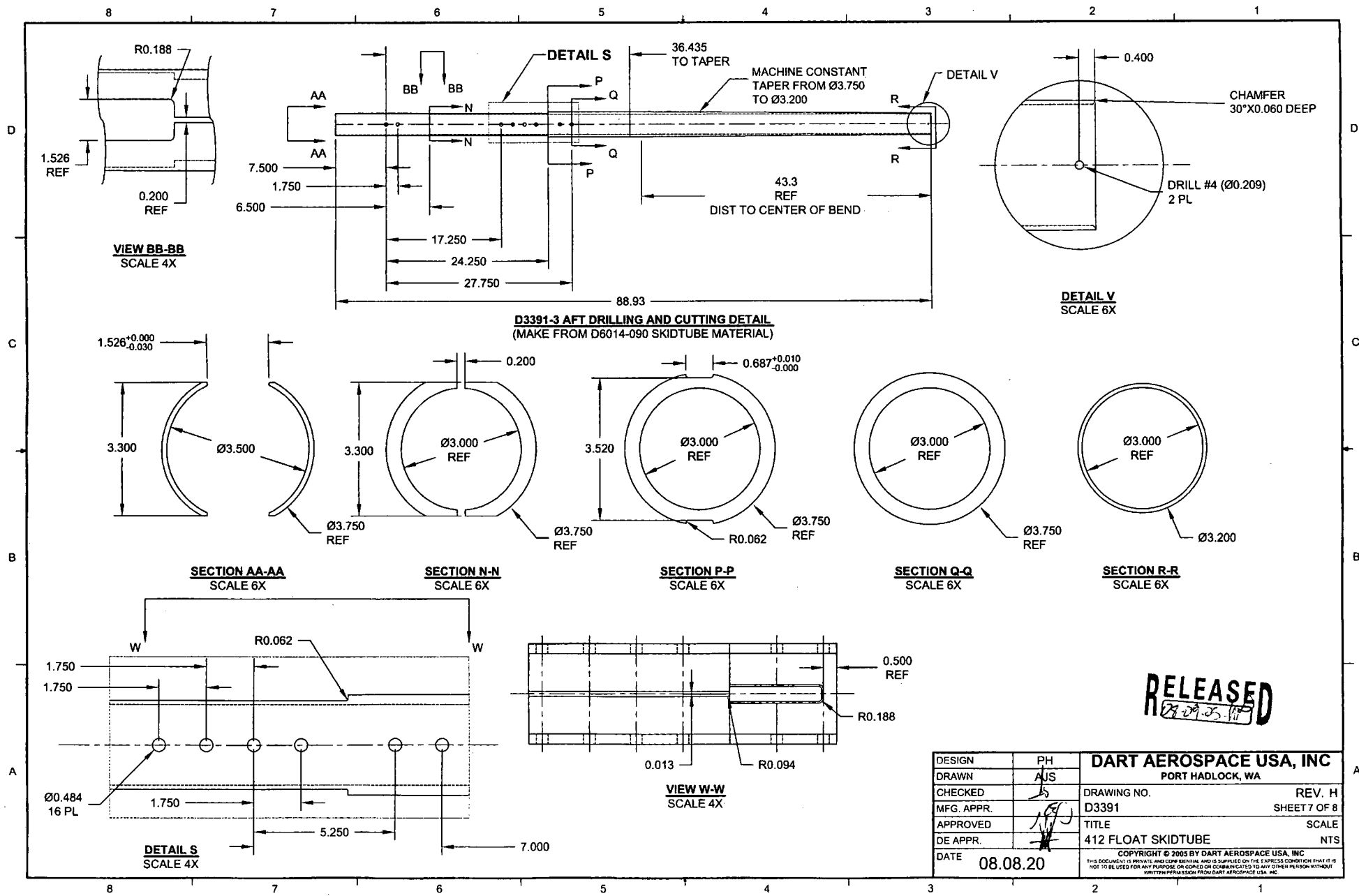
w/o 52793



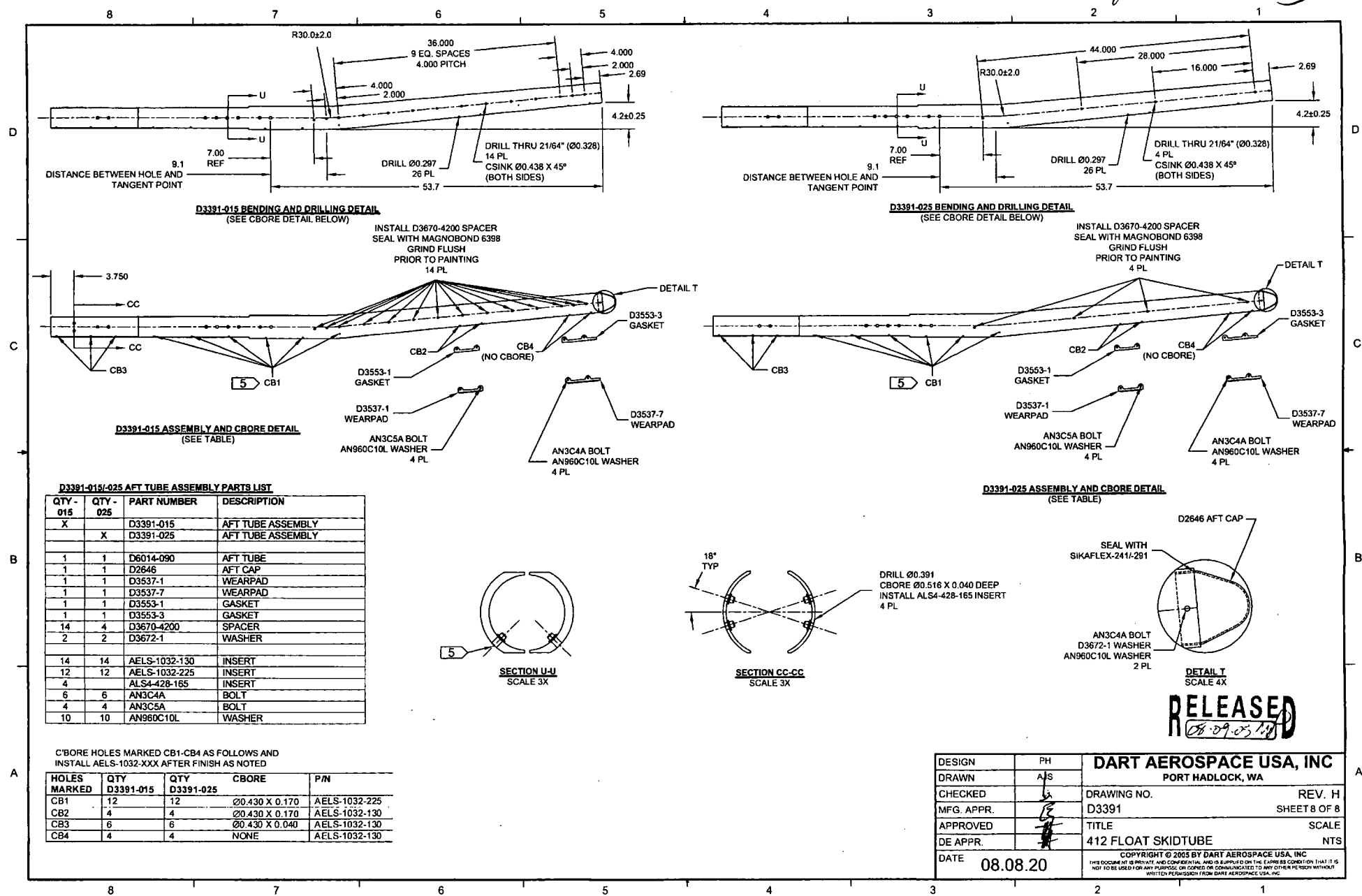
W/O 52793



w/o 52793



W/O 52793



DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	LS	DRAWING NO.	REV. H
MFG. APPR.	B	D3391	SHEET 8 OF 8
APPROVED	1	TITLE	SCALE
DE APPR.	1	412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small> COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE, CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	

NO. 200

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 48025
Part number: D3391 023
Description: Mild tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Bob Dyer Date of Test Coupon 09-06-01

Welder Barclay Elliott Date of Test Coupon 09-06-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld